

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008809**Date Inspected:** 22-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SFOBB Fabrication**Summary of Items Observed:**

CWI Inspector: Mr. Sun Bo

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 9

This QA Inspector observed ZPMC welder Mr. Xiang Jie, stencil 59378 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make internal stiffener to closed rib tack welds for OBG deck plate DP3044-001-321. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector measured a welding current of approximately 220 amps, 25.0 volts and Mr. Xiang Jie is certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Xu Guoyin, stencil 59443 is using flux cored welding procedure WPS B-T-2232-TC-U5F to make internal stiffener to closed rib tack welds for OBG deck plate DP3069-001-324. This QA Inspector observed the base material had been cleaned of oxides where the stiffener welds are to be installed. This QA Inspector measured a welding current of approximately 225 amps, 27.0 volts and Mr. Xu Guoyin is certified to make this weld. Items observed on this date appeared to generally comply with applicable

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contract documents.

This QA Inspector observed ZPMC welder Mr. Jiang Ting Quang, stencil 062265 is using the flux cored welding procedure WPS-345-FCAW-1G(1F)-Repair-1 to make repairs to OBG deck plate DP241-001. Prior to welding the QA Inspector observed the base material appears to have a light layer of rust. This QA Inspector asked ZPMC CWI Mr. Sun Bo if this surface had been cleaned prior to making other weld repairs and Mr. Bo said he will have Mr. Quang obtain a wire brush to clean all the other areas that need to be welded. This QA Inspector measured a welding current of approximately 270 amps and 28.0 volts and the base material has been preheated using a torch. Items observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Dawson,Paul | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
